

Work Order ID 104672

Friday, July 12, 2013 12:40:55 PM

104672

Page 1

Item ID: D3282-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Web (206L/407)
 Start Date: 7/12/2013 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 8/9/2013 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 13-07-12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3282	D								
100	Skidtubes	0.00							
100									
Skidtubes	Memo	0.00							
Skidtubes	1-Cut to length as per Dwg D3282. 2- inspect for surface damage as per QSI0018 3- Deburr								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA579 & Dwg D3282 2-Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

- DC 13/09/11

B.A 13/10/16 10 ~~0~~ SLB-10-17

B.A 13/10/16 10 ~~0~~ SLB-10-17

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QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>2/13/10/18</i>		<i>10</i>	<i>0</i>		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		<i>DGL/mm</i>	<i>13-10-22</i>	<i>10</i>	<i>0</i>		
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00						<i>13-10-23</i>	<i>(10)</i>

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N900040100

Setup Start *NS1*

Item Name: Float Web (206L/407)

Stop *NS2*

Start Date: 7/12/2013 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 8/9/2013 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Install doublers as per Dwg D3282.

176

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: 40 0.00

0.00

180

Packaging

Memo

0.00

Packaging

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Item ID: D3282-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
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Required Date: 8/9/2013 Req'd Qty: 10.00 *10* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

Handwritten: 13-10-24
MF
13-10-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Work Order ID: 104672

104672

Parent Item: D3282-041

D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 7/12/2013

Required Date: 8/9/2013

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B05.09.23Procedure changeKJ/JLM IPP REV:C 11.09.20
remove LPS as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2792-130 Manufactured No

D2792-130
EXTRUSION

100 Each 50.0000 1

**

10

DC 13/09/11

Location

Loc Qty

Loc Code

LG

50

91989

50

10

D3283-1 Manufactured No

D3283-1
Doubler

160 Each 26.0000 2

**

20

DC 13/10/23

Location

Loc Qty

Loc Code

LG

20

99755

20

ST178

6

92179

6

20

MS20470AD4-7 Purchased No

MS20470AD4-7
Rivet, Universal Head

160 Each 7,266.000 57

**

570

DC 13/10/23

Location

Loc Qty

Loc Code

ST336

3222

122452

83

123525

3139

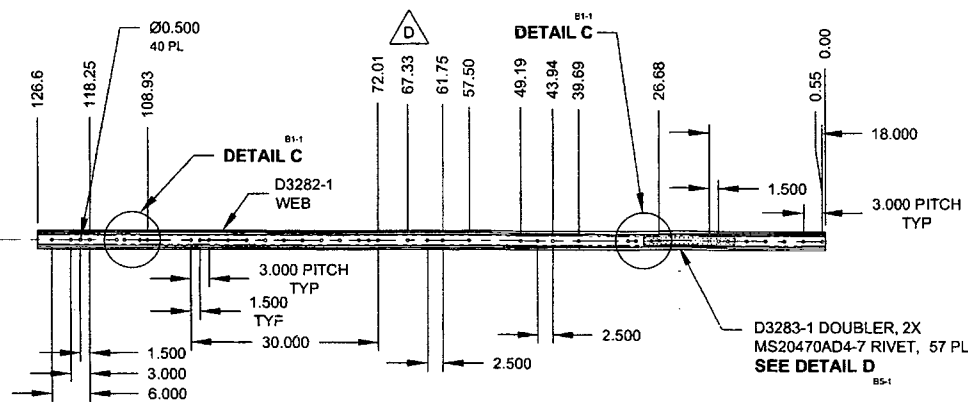
ST509

4044

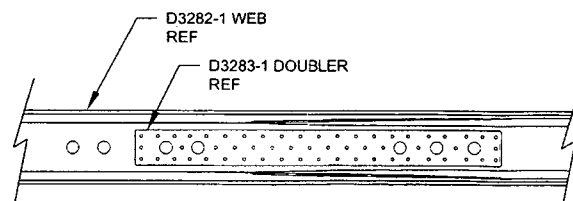
124231

4044

570

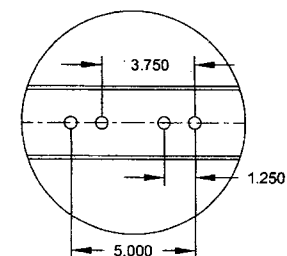


D3282-041 WEB



DETAIL D
C4-1

pl 13-07-12
104672



DETAIL C
D5-1
D6-1

NOTE: RIVET HOLES/DOUBLER
NOT SHOWN FOR CLARITY

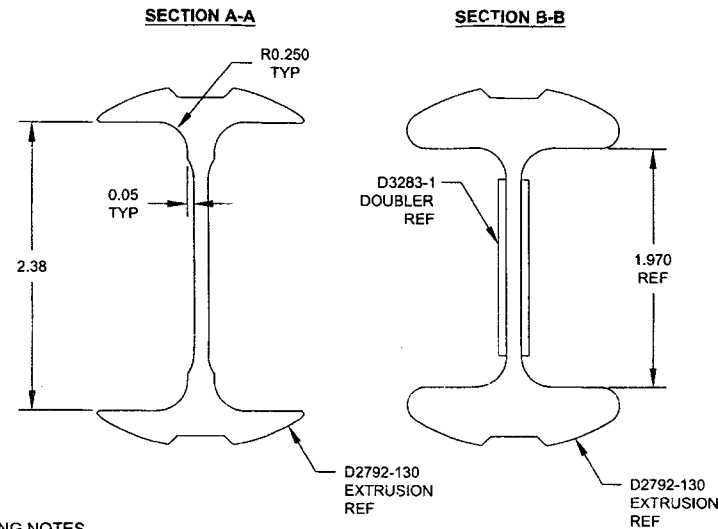
RELEASED
2011-09-12

NOTES:

- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 20.0 lbs
- 8) SEE PAGE 2 FOR MACHINING DETAILS

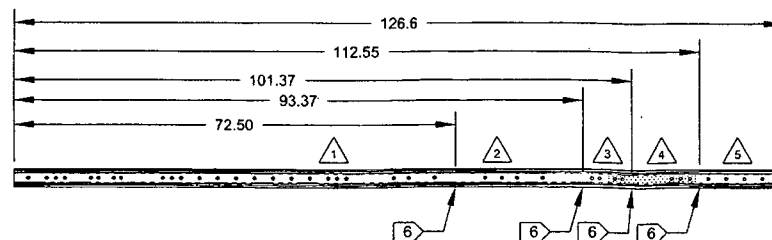
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	<i>JP</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>JP</i>	D3282	SHEET 1 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

1046-19



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
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DART AEROSPACE LTD		Work Order: 104672
Description: FLOAT WEB		Part Number: D 3282-1
Inspection Dwg: D3282 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.250	+/- .010	R0.250	✓		R-6	ref.
0.05	+/- .030	0.047	✓		Dial Ind	HAAS 4
0.55	+/- .030	0.548	✓		Vern	GA-01
1.500	+/- .010	1.500	✓		"	"
26.68	+/- .030	26.68	✓		Tape	GA-12
39.69	+/- .030	39.69	✓		"	"
43.94	+/- .030	43.94	✓		"	"
49.19	+/- .030	49.19	✓		"	"
57.50	+/- .030	57.50	✓		"	"
61.75	+/- .030	61.75	✓		"	"
67.33	+/- .030	67.33	✓		"	"
72.01	+/- .030	72.01	✓		"	"
108.93	+/- .030	108.93	✓		"	"
118.25	+/- .030	118.25	✓		"	"
1.500	+/- .010	1.500	✓		Vern	GA-01
3.000	+/- .010	3.000	✓		"	"
6.000	+/- .010	6.000	✓		"	"

Measured by: D.A. ^{DAS} ₀₈	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 13/10/16 ⁹⁻⁸⁹	Date: 13/10/18	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15